

**D350-5€ 111B DSI**

[illegible]

# Work Order ID 93514

November-16-12 2:11:19 PM

**\*93514\***

Page 1

Item ID: D350-567-115B

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID: PRELIM

Item Name: Interior Floor Window. Blank

Stop **\*NS2\***

Start Date: 16/11/2012 Start Qty: 1.00

**\*1\***

Required Date: 19/11/2012 Req'd Qty: 1.00

**\*1\***

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

DSI 9637

100

**\*100\***

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D350-567-115b

0.00

0.00

CHG001

110

**\*110\***

Packaging

Packaging

Pick Kit

Packaging

Memo

0.00

0.00

120

**\*120\***

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

- inspect 10 Prelim  
Dats only  
not approved

DAS  
16  
2-53

12/11/19

0.00

0.00



*[Handwritten signature]*

*[Handwritten signature]* 12/11/16

# Work Order ID 93514

November-16-12 2:11:19 PM

**\*93514\***

Page 2

Item ID: D350-567-115B

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID: PRELIM

Item Name: Interior Floor Window. Blank

Stop **\*NS2\***

Start Date: 16/11/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 19/11/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-115b								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

B93515

12/12/4 J

DAS 20 9-88

POSITIVE RECALL

EFFECTIVE 12-11-19 AUTH         

RELEASED DAS 16 8-88 DATE 12/12/19

ECW 12-680

is attached

MF 12-11-19

# Picklist Print

November-16-12 2:11:18 PM

Page 1

Work Order ID: 93514

Parent Item: D350-567-115B

Parent Item Name: Interior Floor Window. Blank

Start Date: 16/11/2012

Required Date: 19/11/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.11.16 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<del>D3293-1B</del> Doubler, Blank		Manufactured	No			110	Each	2.0000	0	1	SL		SD
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		2							
				93448		2							
<del>D3294-1B</del> Bracket, Blank		Manufactured	No			110	Each	2.0000	0	1	SL		SD
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		2							
				93450		2							
<del>D3295-1B</del> Window, Blank		Manufactured	No			110	Each	0.0000	0	1	SL		SD
<del>D3296-041B</del> Door Assembly, Blank		Manufactured	No			110	Each	1.0000	0	1	SL		SD
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		1							
				93442		1							
D2463 Seal		Manufactured	No			110	f	563.3863	4.416	4.416			SD
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST403		563.38628							
				72232		15.38							
				79478		0.43737							
				83542		47.56891							
				90297		500							

(D2463-0530) CUT (1) AT 53.00" PER KIT

12/11/19

# Picklist Print

November-16-12 2:11:18 PM

Page 2

Work Order ID: 93514

Parent Item: D350-567-115B

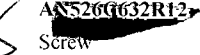





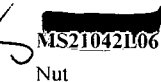





Parent Item Name: Interior Floor Window. Blank

Start Date: 16/11/2012

Required Date: 19/11/2012

Start Qty: 1.00

Required Qty: 1.00

	ANS26G632R12	Purchased	No	110	Each	125.0000		9	
	AN960JD6	Purchased	No	110	Each	50.0000		6	
	MS21042L06	Purchased	No	110	Each	296.0000		9	
	MS20470AD4-5	Purchased	No	110	Each	1,256.0000		2	

# Picklist Print

November-16-12 2:11:18 PM

Page 3

Work Order ID: 93514

Parent Item: D350-567-115B

Parent Item Name: Interior Floor Window, Blank

Start Date: 16/11/2012

Required Date: 19/11/2012

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-6  
Rivet, Universal Head

Purchased No

110 Each 3,805.0000 115 115

## Location

## Loc Qty

## Loc Code

ST336

3805

117395

16

118927

143

119109

12

120142

81

121524

65

122452

489

123021

2999

MS20470AD4-7  
Rivet, Universal Head

Purchased No

110 Each 6,071.0000 15 15

## Location

## Loc Qty

## Loc Code

ST336

6071

116081

117

118614

148

120769

52

121415

124

122452

630

123525

5000

## 5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
			1	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			1	8	AN960JD6	WASHER
			1	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET

# **ENGINEERING CHANGE NOTICE** **DART AEROSPACE LTD**

Date:	12.11.20	Job No.:	ENG3100NOV	ADR Yes/No:	Y	ADR Date:	12.11.15	ECN #:	12- 680
Product No.:	D350-567-111B			Created By:	[Signature]		Approved By:	[Signature]	
Product Name:	FLOOR WINDOW INSTALL, EXTRA LARGE (BLANK)			Checked By:	[Signature]				

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	IE	N/A
Production Manager / Coord.	Y	LL/MF	12.11.21
Purchasing Coord.	N	CL	
Production Engineering Coord.	Y	DD	12.12.03
Production Engineering Coord.	N	JLM	
Customer Order Processing	N	RM	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DOA / QA Coord.	Y	PS	12.11.21
QC Coordinator	Y	ED	12.11.21
Customer Support	Y	SW/LM	12.11.21
Customer Technical Support	Y	MB/DS	12.11.21
Marketing	Y	HM	12.11.21

**Reason for Change:**  
PER PAR12-223, CUSTOMER UPGRADING FROM OEM SMALL WINDOW INSTALL TO DART EXTRA LARGE WINDOW INSTALL: BLANK PARTS REQ'D

**Documents Affected:**  
RELEASE DSI 9637 REV. A, D3293 REV. B, D3294 REV. D, D3295 REV. E, D3296 REV. B

**PAPERWORK UPDATE** ☒ **PARTS MUST COMPLY** ☐ **PREVIOUS PARTS SATISFACTORY** ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	Y	MB/PS	SEE BELOW.	12.11.21
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	MB	MDL-D350-567 REV. J	12.11.21
6	Update Product Compatibility Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		12.11.21
11	Update Product Specification Files	Y	KJ	DSI 9637 REV. A ON REQUEST ONLY	12.11.21
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		12.11.21
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	KJ	SEE BELOW.	12.11.21
17	Update / Verify ARC Database	Y	KJ	#4	12.11.21
18	Create / Update Change Record Form / Item Card Database	Y	KJ	D350-567-111B/-115B @ CHG 001	12.11.21
19	Create / Update PPP's	Y	KJ	D350-567-111B/-115B	12.11.21
20	Red Decals required?	Y	KJ	D350-567-111B/-115B	12.11.21
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ		12.11.21
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		12.11.21
24					

**Description / Action:**

- PROVIDE MBH TECHNICS WITH DSI 9637 AND ARC
- ENSURE ALL NEW PARTS ARE IN SYSTEM: B350-567-111B/-115B, D3293-1B, D3294-1B/-3B/-3BF/D3295-041B/-1B, D3296-041B

ECN Verified & Complete: [Signature] Date: 12/12/21



# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1  
REF. TCCA STC: SH92-18  
REF. FAA STC: SH989NE AND SH990NE  
REF. EASA STC: EASA.IM.R.S.01560 AND EASA.IM.R.S.01561

## 1.0 PURPOSE

This service instruction is intended for customers wishing to upgrade their existing OEM small vertical reference window kit to a DART D350-567-111 Floor Window Kit. Since the DART D350-567-115 Floor Window Kit included with D350-567-111 does not share the same rivet patterns as the OEM kit, the D350-567-111B/-115B Kits from this service instruction replaces the D350-567-111/-115 Kits to facilitate installation without having to perform extensive rework/repair of the aircraft floor prior to installation.

## 2.0 INSTALLATION OF D350-567-111B:

**Note:** With reference to Installation Instructions D350-567, make the following substitutions:

- D3293-1B replaces D3293-1;
- D3294-1B replaces D3294-1;
- D3295-041B replaces D3295-041;
- D3296-041B replaces D3296-041.





- 2.1 Perform Step 3.3.1 of Installation Instructions D350-567 as required.
- 2.2 Locate the D3293-1B per Figure 1 of this service instruction.
- 2.3 Enlarge the viewing hole in the aircraft floor by using D3293-1B as template.
- 2.4 Transfer drill  $\varnothing 0.128$ " holes from the aircraft floor to D3293-1B Doubler, D3294-1B Bracket, and D3295-041B Window. Drill additional holes as required through D3293-1B and aircraft floor. Ensure minimum pitch and edge distance as indicated.
- 2.5 Enlarge existing  $\varnothing 0.128$ " holes to  $\varnothing 0.141$ " as required and drill qty(4)  $\varnothing 0.141$ " as shown in Figure 1 of this service instruction for a total of qty(9)  $\varnothing 0.141$ " holes.
- 2.6 Locate D3296-041B and transfer drill qty(12)  $\varnothing 0.128$ " and qty(3)  $\varnothing 0.141$ " holes from the D3293-1B Doubler/aircraft floor to the blank hinge blade of D3296-041B.
- 2.7 Complete installation in accordance with Section 3.3 of Installation Instructions D350-567.
- 2.8 Touch up finish on drilled parts in accordance with Section 5.1.3 of ICA-D350-567.
- 2.9 Install the D350-567-113 Kit per Section 3.7 of D350-567. No changes.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 12.11.16  
CERT. NO.: SH92-18  
ISSUE NO.: 6

A	NEW ISSUE	MB	12.11.15
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9637	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		INSTALL MOD	NTS
DATE	12.11.15	COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

### 3.0 PARTS LIST

QTY -111B	QTY -113	QTY -115B	Part Number	Description
X			D350-567-111B	FLOOR WINDOW INSTALLATION, EXTRA LARGE (BLANK)
1	X		D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
1		X	D350-567-115B	INTERIOR FLOOR WINDOW KIT (BLANK)
	1		D2463-0860	NEOPRENE SEAL
	1		D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
	12		2600-6	1/4 TURN FASTENER
	12		2600-LW	WASHER
	12		212-12	RECEPTACLE
	21		AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	42		AN960JD8	WASHER
	21		MS21042L08	NUT (OR MS21042-08)
	24		MS20426AD3-5	RIVET
	2 SQ. YD		N/A	9.7 OZ 7781 'S' GLASS UNIVERESAL WEAVE
		1	D3293-1B	DOUBLER, BLANK
		1	D3294-1B	BRACKET, BLANK
		1	D3295-041B	FLOOR WINDOW, BLANK
		1	D3296-041B	DOOR ASSEMBLY, W/BLANK HINGE BLADE
		1	D2463-0530	NEOPRENE SEAL
		9	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
		9	AN960JD6	WASHER
		9	MS21042L06	NUT (OR MS21042-06)
		2	MS20470AD4-5	RIVET
		115	MS20470AD4-6	RIVET
		15	MS20470AD4-7	RIVET

### 4.0 WEIGHT AND BALANCE

For D350-567-111B, use the weight and balance information for D350-567-111..

### 5.0 MAINTENANCE AND CONTINUED AIRWORTHINESS






Maintenance and continued airworthiness instructions for D350-567-111B is the same as for D350-567-111. Refer to ICA-D350-567.

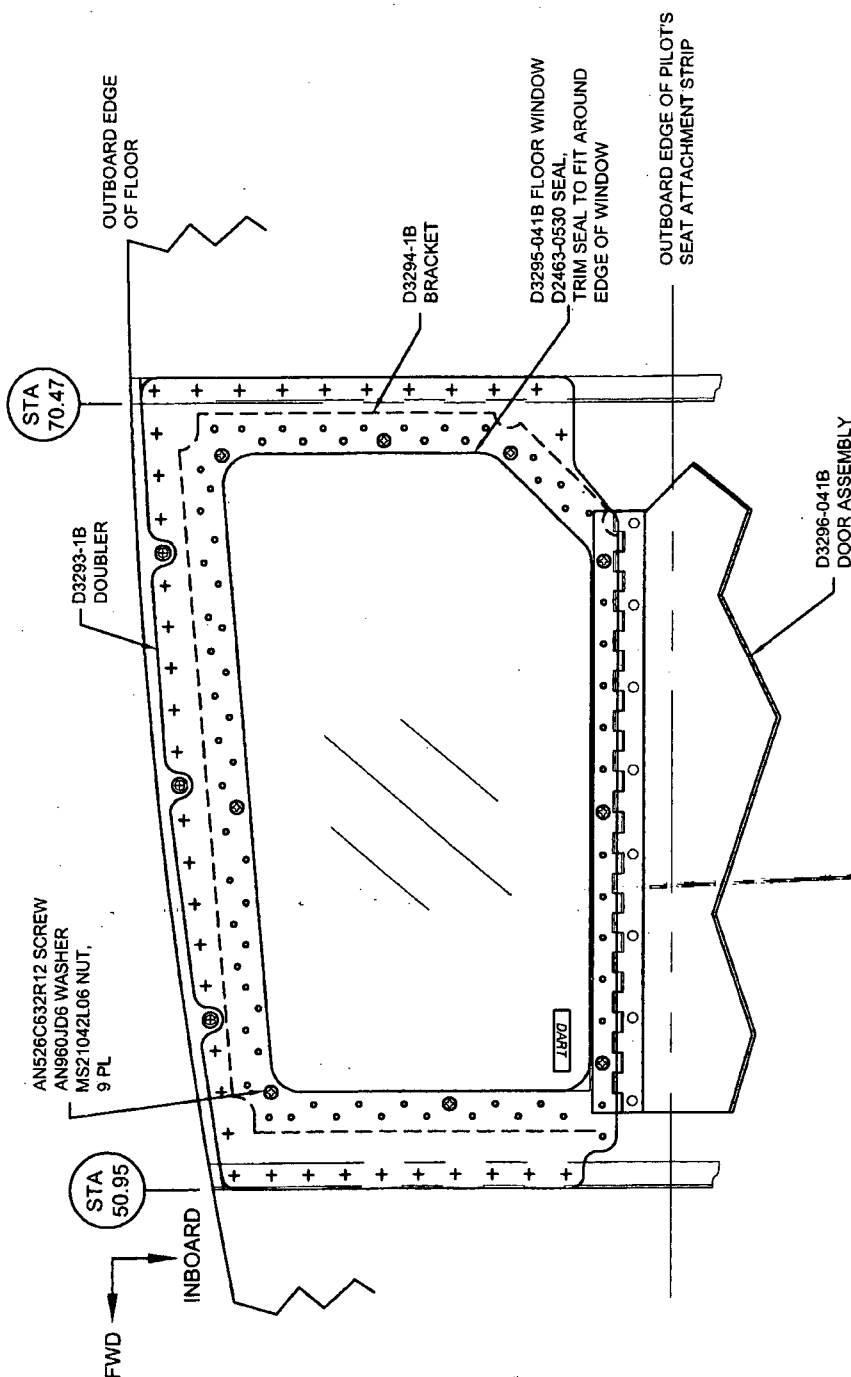
CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 12.11.16  
CERT. NO.: SH92-18  
ISSUE NO.: 6

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9637	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		INSTALL MOD	NTS
DATE	12.11.15	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**FIGURE 1: D350-567-115B KIT OVERVIEW**  
(SLIDING DOOR MOD NOT SHOWN)

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

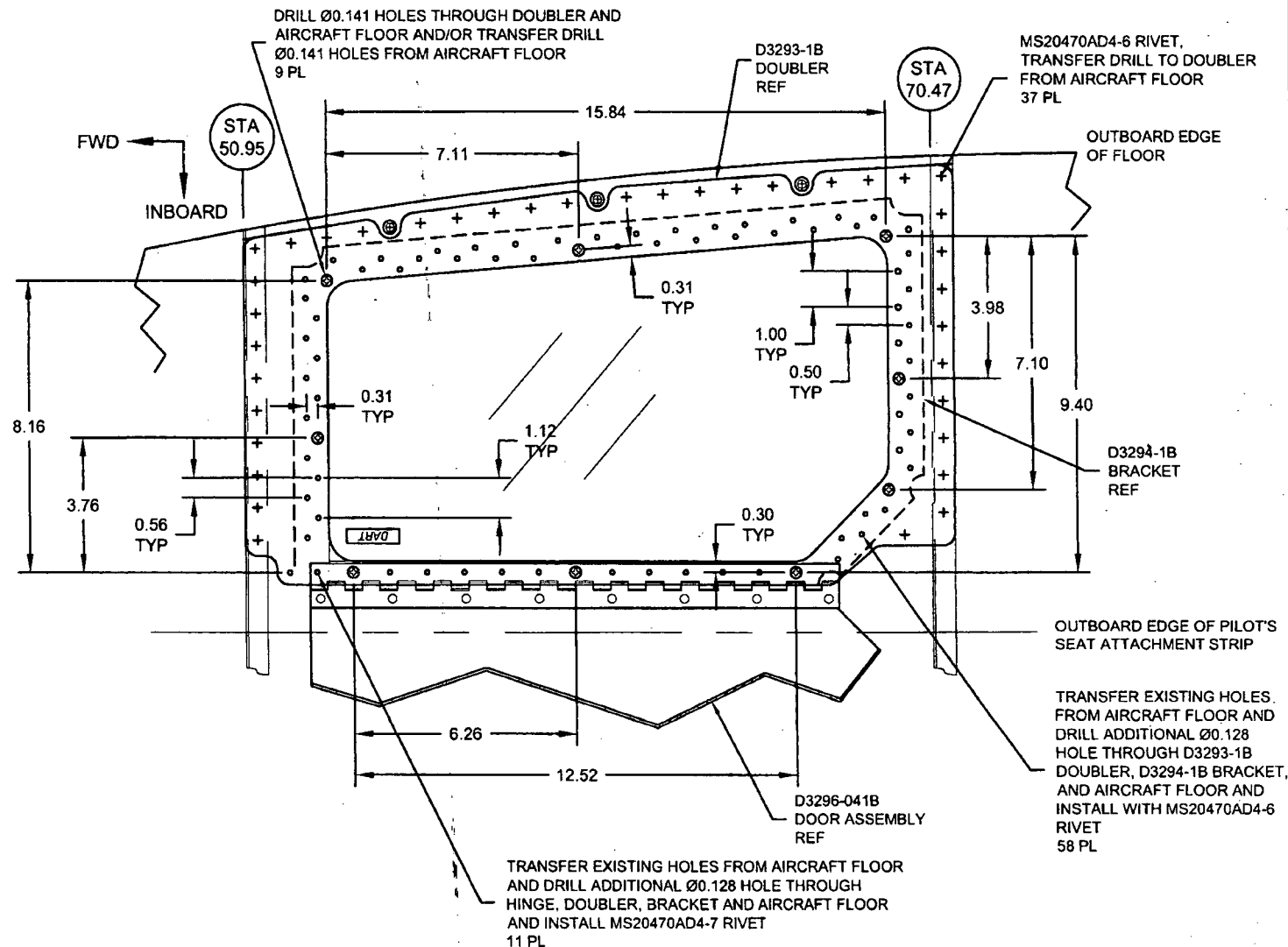
APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)  
DATE: 12.11.16  
CERT. NO.: SH92-18  
ISSUE NO.: 6

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9637	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	INSTALL MOD	NTS
DATE	12.11.15	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: D. SHEPHERD (DE # 02)  
DATE: 12.11.16  
CERT. NO.: SH92-18  
ISSUE NO.: 6

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		TITLE
DATE	12.11.15	INSTALL MOD
		REV. A
		SHEET 4 OF 4
		SCALE
		NTS



**FIGURE 2: TYPICAL PITCHES FOR  
ADDITIONAL REQUIRED RIVETS**  
(SLIDING DOOR MOD NOT SHOWN)

COPYRIGHT © 2012 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.